

Work Order ID 147434

Wednesday, June 08, 2016 3:19:11 PM

147434

U/R

Page 1

Item ID: D412-704-015 *updated BOM as per ECN 16-577* Accept ***N19000040100*** Setup Start ***NS1***
Revision ID: URF 16-577 Stop ***NS2***
Item Name: Co-Pilot's Emergency Cargo Release
Start Date: 6/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/17/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: JUN 10 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	<i>E</i> <i>OK</i> <i>16/6/14</i> DOCUMENT CONTROL	<i>AUG 05 2016</i> 0.00	<i>DAS</i> <i>6</i> <i>9-89</i>						
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-015 CHG002		<i>DAS</i> <i>21</i> <i>9-89</i>						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

AUG 28 2016

AUG 17 2016

AUG 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 147434

Wednesday, June 08, 2016 3:19:11 PM

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Item ID: D412-704-015

Accept

N900040100

Setup Start ***NS**

Revision ID: URF 16-577

Stop ***NS**

Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR**

Stop ***NR**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	S
130	Packaging	0.00							
130									
Packaging	Memo	0.00			DAS 28 9-89	DAS 27 9-89			
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02				DAS 21 9-89			
Quality Control									

AUG 28 2016

AUG 29 2016

AUG 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 147434

147434

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP
REV:B 12.04.20 per cen-566 DD verf:EC IPP REV:C
12.05.10 per ECN 12-583 DD verf:EC IPP REV:D 16.06.22
PER IIN REV:E DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3206-3 Pedal Arm		Manufactured	No				Each	4.0000		1			DAS 6 9-89
D3206-3									**				B148076 PC
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					prelim			4					
					146154			4					
D412-704-141 Pedal Assembly		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D412-704-141									**				150553 PC
D412-704-045 Cable Ass'Y		Manufactured	No			110	Each	2.0000	1	1			DAS 6 9-89
D412-704-045									**				B145771 PC
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST215			2					
					147412			2					
D3207-5 Bracket		Manufactured	No			110	Each	4.0000	1	1			DAS 6 9-89
D3207-5									**				B147507 PC
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST024			4					
					116991			4					

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Work Order ID: 147434

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3207-7

Manufactured No

110 Each

62.0000

1 1

D3207-7

Packer

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST024

62

110077

3

145451

59

D3207-9

Manufactured No

110 Each

4.0000

1 1

D3207-9

Bracket

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST024

4

122604

4

D3208-1

Manufactured No

110 Each

12.0000

1 1

D3208-1

Doublet

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST025

12

141492

12

D3208-11

Manufactured No

110 Each

14.0000

1 1

D3208-11

Filler

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST026

14

141386

14

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Work Order ID: 147434

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3208-3

Manufactured No

110 Each

15.0000

1 1

D3208-3

Pedal Mount Angle

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST025

15

146022

15

D3208-7

Manufactured No

110 Each

13.0000

1 1

D3208-7

Filler

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST025

13

142866

13

D3208-9

Manufactured No

110 Each

10.0000

1 1

D3208-9

Doubler

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST025

10

142241

10

D3214-1

Manufactured No

110 Each

12.0000

1 1

D3214-1

Decal

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST026

12

141572

12

D4610-1

Manufactured No

110 Each

7.0000

1 1

D4610-1

Doubler

**

PC 

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

7

119696

7

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Work Order ID: 147434

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4610-3

Manufactured No

110 Each

16.0000 1 1

D4610-3

Doubler

**

PC

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

16

142233

16

D4610-7

Manufactured No

110 Each

20.0000 1 1

D4610-7

Cover

**

PC

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

20

142239

20

MS21919-DG5

Purchased No

110 Each

20.0000 4 4

MS21919-DG5

Clamp

**

PC

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST293

20

m134134

20

D4622-1

Manufactured No

110 Each

9.0000 1 1

D4622-1

Placard

**

PC

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

st113

9

132587

3

147430

6

6/20/2017

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Work Order ID: 147434

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D4622-3

Manufactured No

110 Each

5.0000

1

1

D4622-3

**

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

st113

5

132697

5

MS35489-149

Purchased No

110 Each

85.0000

1

1

MS35489-149

**

GROMMET

Location

Loc Qty

Loc Code

ST269

85

121692

85

DAS
27
9-89

AUG 17 2016

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
		1					D3206-3	PEDAL ARM
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER
				1			MS20004-24	BOLT

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
4	4	4					MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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Item ID: D412-704-015 *updated BOM* Accept

Revision ID: URF 16-577 *as per ECN*

Item Name: Co-Pilot's Emergency Cargo Release *16-577*

Start Date: 6/10/2016 Start Qty: 1.00 ***1***

Required Date: 6/17/2016 Req'd Qty: 1.00 ***1***

Reference:

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: ML3 Date: JUN 10 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN-D412-704	D UR OK <i>16/6/14</i>	<i>AUG 05 2016</i>	<i>DAS 8 9-89</i>				<i>DAS 21 9-89</i>	<i>AUG 05 2016</i>	
100	Document Control	0.00							

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and create labels per PPP D412-704-015 CHG002

DAS 21 9-89

see attachment

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

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CO-PILOT EMERGENCY CARGO RELEASE (412)

[illegible]